

Work Order ID 66127

Monday, February 07, 2011 10:53:02 AM



Page 1

Item ID: D3500-1

Accept



Setup

Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 2/8/2011

Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/2011

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MLFDate: 11-02-07

QC: _____

Date: _____

SPC (Y/N): _____

Tooling: _____ Date: _____

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							

100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

Program Batch No. 66127 Double check by: _____ 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect p

SL 11/04/11

(9)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/04/11

(9)

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

A. A 11/04/12

9

d

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66127

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Monday, February 07, 2011 10:53:02 AM

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 2/8/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

9 d M u/o+liz

HandFinish

Memo

0.00

Hand Finishing

140



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 116946

Memo

0.00

Powdercoat

START TIME:

3:55

OVEN TEMPERATURE:

FINISH TIME:

4:05

9 b 11-4-13

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

9 d M 114114

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, February 07, 2011 10:52:58 AM

Work Order ID: 66127



Parent Item: D3500-1



Parent Item Name: Saddle

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 		Manufactured	No			100	Each	20.0000	1	12		2/11/2011	

Saddle Billet

Location	Loc Qty	Loc Code
MAT43	20	0
59467	30	0
60713	80	0
61300	10	0
64278	8	8
62010	1	1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 66127	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.376	.376	.376		
F	0.490	0.510		.498	.499	.498	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.588	1.588	1.588		
J	0.240	0.260		.245	.248	.248	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.136	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.252	.253	.252	.252		
AE	1.810	1.830		1.822	1.823	1.822	1.820		
AF	0.240	0.260		.250	.249	.250	.250		
AG	0.140	0.160		.147	.150	.150	.150		
AH	0.140	0.160		.152	.153	.154	.152		
AI	0.140	0.160		.156	.155	.155	.154		

Accept/Reject

Measured by:	SL	Audited by:	H.A
Date:	11/04/11	Date:	11/04/12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 166/27

Description: Saddle

Part Number: D3500-1

Inspection Dwg: D3500

Rev: C

Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	45	46	47	48	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.376	.376	.376		
F	0.490	0.510		.498	.500	.499	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.247	.249	.247	.246		
K	0.490	0.510		.499	.500	.500	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.251	.251	.252	.252		
AE	1.810	1.830		1.819	1.819	1.819	1.820		
AF	0.240	0.260		.249	.250	.250	.249		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.153	.152	.154	.153		
AI	0.140	0.160		.155	.154	.155	.153		
Accept/Reject									

Measured by: JL
Date: 11/04/11

Audited by: H.A
Date: 11/04/12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AD



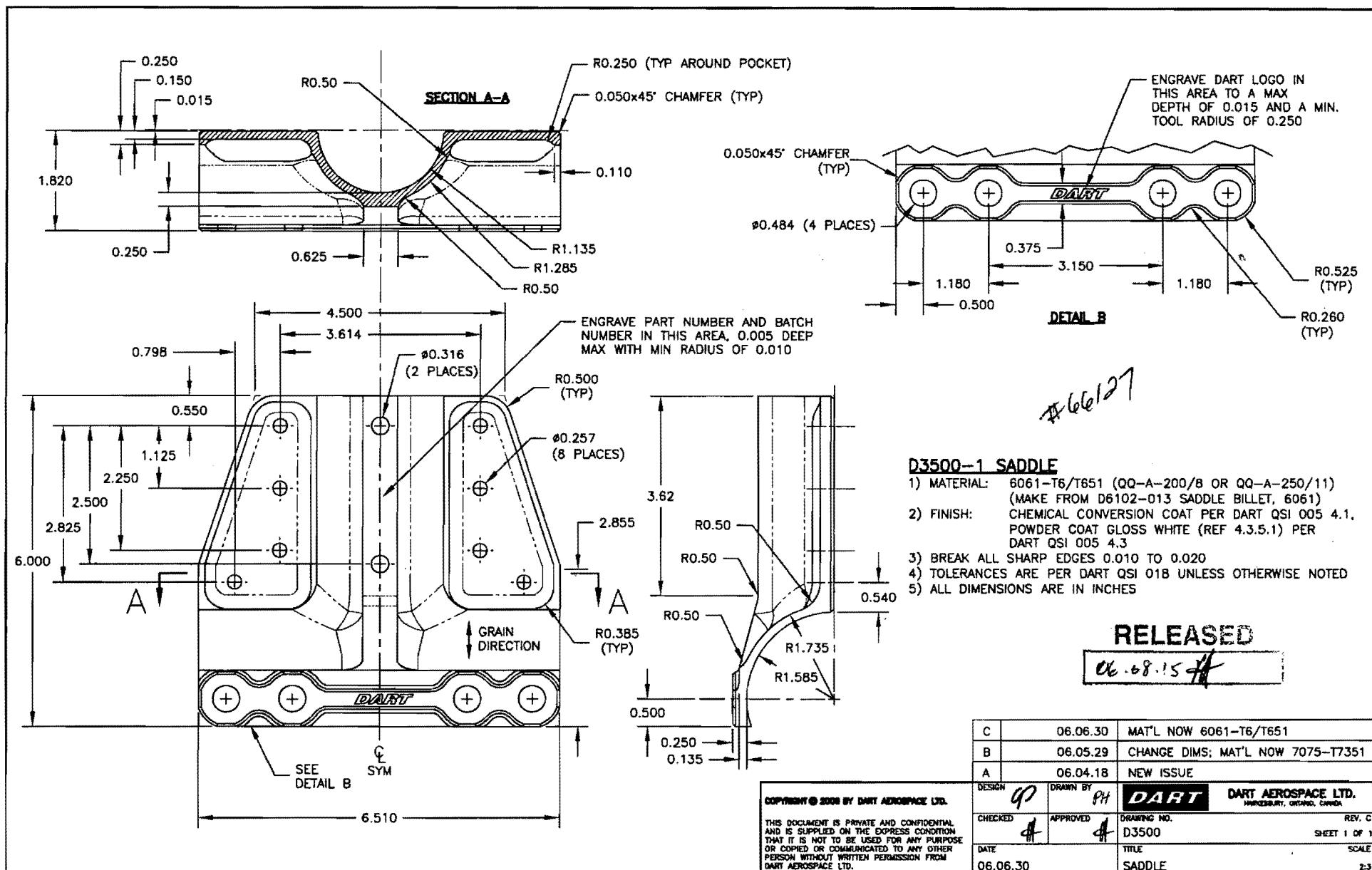
DART AEROSPACE LTD				Work Order: 66127			
Description: Saddle				Part Number: D3500-1			
Inspection Dwg: D3500 Rev: C				Page 1 of 1			

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485					
B	1.175	1.185		1.180					
C	3.145	3.155		3.150					
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E	0.365	0.385		.376					
F	0.490	0.510		.500					
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588					
J	0.240	0.260		.247					
K	0.490	0.510		.500					
L	3.590	3.650		3.620					
M	0.315	0.322		.316					
N	0.256	0.262		.258					
O	6.500	6.520		6.510					
P	5.990	6.010		6.000					
Q	2.820	2.830		2.825					
R	2.495	2.505		2.500					
S	2.245	2.255		2.250					
T	1.120	1.130		1.125					
U	0.540	0.560		.550					
V	0.793	0.803		.798					
W	R.240	R.260		.250					
X	0.040	0.060		.050					
Y	0.100	0.120		.105					
AA	R1.125	R1.145		1.135					
AB	R.490	R.510		.500					
AC	0.615	0.635		.635					
AD	0.240	0.260		.251					
AE	1.810	1.830		1.820					
AF	0.240	0.260		.250					
AG	0.140	0.160		.150					
AH	0.140	0.160		.153					
AI	0.140	0.160		.153					
Accept/Reject									

Measured by:	SL	Audited by:	A.A
Date:	11/04/11	Date:	11/04/11

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	MM





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries